

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:02:21 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/66/25 + 14

Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- weld as per dwg B67-43001

8.0 MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Nutplate

M108601

ep08/07/17

9.0 MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 60.0000 Each(s)

RIVET

M105978

ep08/07/17

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- install nut plates as per dwg B67-43001

11.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: M114

ep08/07/17 + 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/07/17	7.1	Small fab grind weld flush	SAD	08/07/07	4		
	7.2	QC 10	SAC (07/07/07)	08/07/07	14		
	7.3	QC 5	SAC (07/07/07)	08/07/07	44		
	7.4	Hand finish chemical conversion coat	SAC	08/07/07	14		
	7.5	QC 3	SAC	08/07/17	(44)		
		* All permanent changes	AM	08/06/17			

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Drawing Name: SUPPORT PLATE

Job Number: 40027

Part Number: PB6743001159

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

L Douglas

Job Completion



6/08.08.01

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD	Work Order:	
Description: SIDE SUPPORT PLATE	Part Number:	B67-43001
Inspection Dwg:	Rev: B	Page 1 of 1

- 159

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

119295

714

Measured by: <u>BS</u>	Audited by: <u> </u>	Prototype Approval: <u> </u>
Date: <u>8-6-24</u>	Date: <u>03/06/24</u>	Date: <u> </u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

REFERENCE ON V

RELEASED
04-04-20

10

2-73 20 DEGREES COVER PLATE
MATERIAL: .032 THK. 6061-T6, 00-A-250/11
SCALE 0.500

* FINAL DM of Drawing: 4.0

A diagram of a right-angled triangle. The vertical leg is labeled "8.127 ft" and the horizontal leg is labeled "0 ft".

A technical drawing of a mechanical part, likely a bracket or frame. The top horizontal dimension is 21.15. The right vertical dimension is 8.22. The right horizontal dimension is 8.20. The bottom right vertical dimension is 2.1. The bottom horizontal dimension is 2.06. The left vertical dimension is 1.53. The left horizontal dimension is 1.52. The drawing shows a stepped profile with a central horizontal slot and vertical supports.

Date: Friday, 7/4/2008 8:45:48 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SUPPORT PLATE		
Job Number	40244		Part Number	PB674300171		
Estimate Number	13385		Drawing Number	B6743001 P.9/26		
P.O. Number	:		Project Number	N/A		
This Issue	7/4/2008	S.O. No. :	Drawing Revision	B1		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : SMALL /MED FAB	Due Date	7/10/2008	Qty:	10
Previous Run	40027		Um:	Each		
Written By	:					
Checked & Approved By	:		See first page			
Comment	:		Est Rev:A 08-06-19 new issue DD verified by:ec			
			Est Rev:B 08-06-27 procedure chg DD vrfied by:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S090	6061-T6 .090 Sheet
Comment: Qty.: 0.8594 sf(s)/Unit Total : 8.5943 sf(s) 6061-T6 .090 Sheet batch:		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg B67-43001-159 Dwg Rev: _____ Prog Rev: _____ ****grain direction along 5.750" **** 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg B67-43001		

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Date: Friday, 7/4/2008 8:45:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-weld as per dwg B67-43001

JZ 08.01.

8.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-grind weld flush

SAD 08.01.

9.0 QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 MS21075L3

Nutplate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Nutplate

14.0 MS20426AD34

RIVET



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

RIVET

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Date: Friday, 7/4/2008 8:45:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT PLATE

Job Number: 40244

Part Number: PB674300171

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-install nut plates as per dwg B67-43001

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

18.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

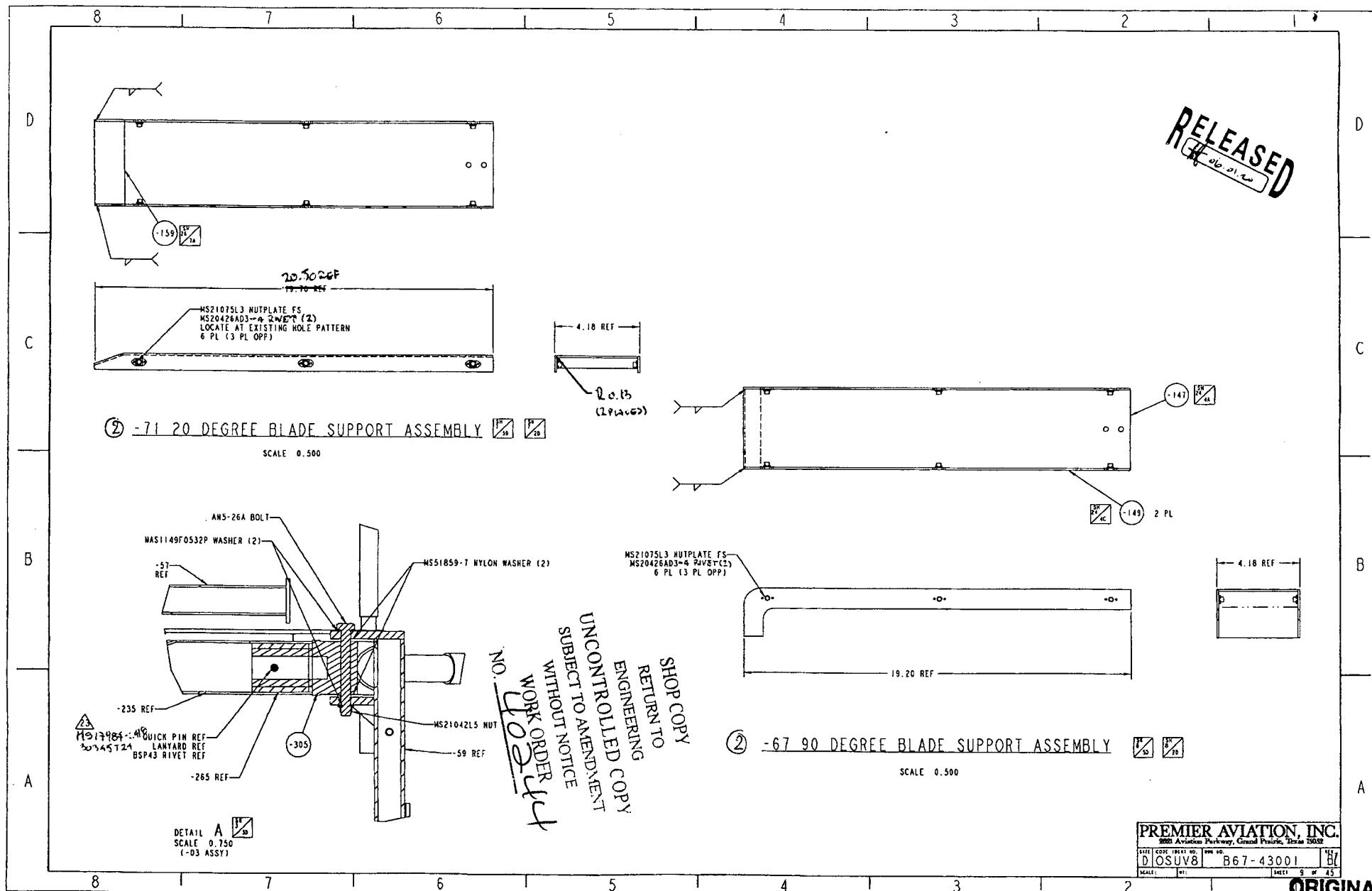


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NOTE: Date & initial all entries



PREMIER AVIATION, INC.
2000 Aviation Parkway, Grand Prairie, Texas 75092
FILE CODE: INK1 NO. 00010
DOSUV8 B67-43001
SCALE: 1/1
NET 9 of 45

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

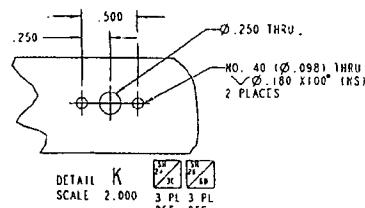
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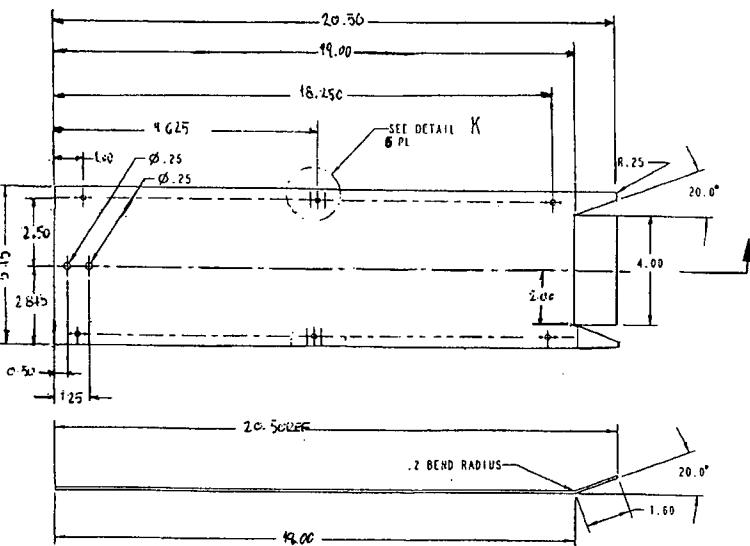
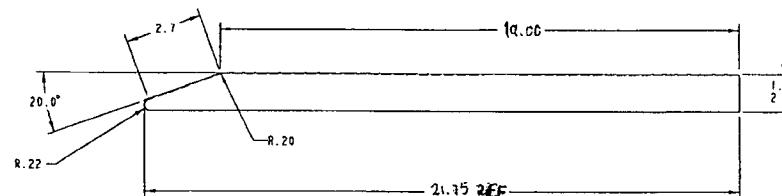
NOTE: Date & initial all entries

RELEASED
4/6/2020

11-06-4-20



DETAIL K
SCALE 2.000



② - 159 SUPPORT PLATE SN 88
MATERIAL: .090 THK, 6061-T6, 00-A-250/11
SCALE 0.500

SCALE 0.500

SCALE 0.500

PART 13 SYMMETRICAL ABOUT CENTER LINE

(2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40244

② -73 20 DEGREE COVER PLATE

MATL: .032 THK, 6061-T6, QD-A-250/1
SCALE 0.500

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40244

PREMIER AVIATION, INC.			
2821 Aviation Parkway, Grand Prairie, Texas 75052			
SIZE	CODE	ITEM NO.	QTY.
D	DOSUV8	B67-43001	REV. B
ASME 1	11	ASME 1	26.00

ORIGINAL

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